

Amendments to the Claims

This listing of claims replaces all prior versions, and listings, of claims in the application.

Listing of Claims

1. (Previously presented) A base insert device for the formation of crossed bases in crossed base valve paper bags, said device comprising:

 folding devices which introduce folds at ends of tubular sections from which the bags are produced;

 one or more gluing stations, which apply glue to regions of the folds for gluing and/or to sheets provided for gluing to the bases in the gluing stations; and

 at least one pressing station in which the folded bases and the sheets are brought into contact and glued,

 at least one of the gluing stations including glue outlet openings which may be selectively supplied with glue such that the selection of the glue outlet openings defines a format of the glue application, and

 said glue outlet openings being provided with at least two application heads of which at least one application head is displaceable in a direction orthogonal to a feed direction of the sheets and/or the folded bases such that as a result of the

displacement, a relative movement of the two application heads occurs.

2. (Previously presented) The base insert device according to claim 1 wherein each application head is provided with an application plate in which several glue outlet openings are each arranged equidistantly at a distance (A) on one line in a direction perpendicular to the feed direction of the sheets and/or the folds of the bases, the application plates being configured such that adjoining glue outlet openings of two different application heads are positionable at a different distance than the distance (A).

3. (Previously presented) The base insert device according to claim 1 wherein the two application heads are displaceably supported on a common guide rail.

4. (Previously presented) The base insert device according to claim 1 further comprising at least one spindle drive that provides the force to move at least one of the displaceable application heads.

5. (Previously presented) The base insert device according to claim 4 wherein the spindle is driven using a motor.

6. (Previously presented) The base insert device according to claim 1 further comprising a device that automatically displaces the application head and a control unit that controls the displacement.

7. (Previously presented) The base insert device according to claim 6 wherein a target image of the glue application is supplied to the control unit and the control unit calculates target positions of glue traces that are extruded from the glue outlet openings based on the target image.

8. (Previously presented) The base insert device according to claim 6 wherein the device that automatically displaces the application head includes a spindle attached to an outer application head and a rod that supports the application heads in a frame, and said base insert device further comprising position sensors which record an actual position of the spindle and/or the rod and notify the control unit.

9. (Previously presented) The base insert device according to claim 1 wherein all of the application heads of the gluing station are supplied with glue from one common glue supplying line.

10. (Previously presented) The base insert device according to claim 9 wherein the glue supplying line extends in a direction substantially orthogonal to the feed direction of the sheets and/or of the bases of the bags.

11. (Previously presented) The base insert device according to claim 9 wherein the glue supplying line is configured as a guide rail.

12. (Previously presented) The base insert device according to claim 1 further comprising guide elements which guide bag components to be glued in the region of the gluing station, the guide elements being displaceable together with the displaceable application head.

13. (Previously presented) A method of operating the base insert device according to claim 3, wherein one of the application heads

remains stationary with respect to the guide rail during the format adjustment.

14. (Previously presented) The method according to claim 13 wherein the format is defined by three application heads including a middle head that remains stationary with respect to the guide rail during the adjustment of the format.

15. (Previously presented) A base insert device that forms a crossed base in a crossed base valve paper bag comprises:

a folding device that introduces folds at a base end of a bag section;

a gluing station that applies glue to the folds that are to be glued and/or to a sheet that is to be glued to the base end, the gluing station including at least two application heads having a plurality of glue outlet openings that are selectively supplied with glue such that the selected openings define a format of the glue application, at least one of the application heads being displaceable in a direction orthogonal to a feed direction of the folded bag section and/or the sheet such that as a result of the displacement, a relative movement between the two application heads occurs; and

a pressing station that contacts the applied glue, the folded base end, and the sheet so as to form the crossed base.

16. (Previously presented) The base insert device according to claim 15, wherein the head is displaceable such that a separation distance between a glue outlet opening of a first head and a glue outlet opening of a second head is less than a distance between adjacent glue outlet openings on each of the heads.

17. (Previously presented) A base insert device that forms a crossed base in a crossed base valve paper bag comprises:

a folding device that introduces folds at a base end of a bag section;

a gluing station that applies glue to the folds that are to be glued and/or to a sheet that is to be glued to the base end, the gluing station including at least two application heads with at least one of the application heads being displaceable in a direction orthogonal to a feed direction of the folded bag section and/or the sheet such that as a result of the displacement a relative movement between the two application heads occurs, and each application head having an application plate that includes a plurality of glue outlet openings arranged linearly and equidistantly at a distance (A) in a direction

perpendicular to the feed direction of the folded bag section and/or the sheet, the application plates being configured such that adjacent glue outlet openings of two different application heads are positionable at a different distance than the distance (A); and

a pressing station that contacts the applied glue, the folded base end, and the sheet so as to form the crossed base.

18. (New) The base insert device according to claim 1, wherein the gluing stations and the glue outlet openings are configured to apply a starch glue.

19. (New) The base insert device according to claim 1, wherein the glue is a starch glue.